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SPLIT

DART AEROSPACE LTD	Work Order:	19665 <del>19665</del> D
Description: Aft Crosstube	Part Number:	D2890
Drawing: D2890 Rev. B; D6008 Rev. A	Qty:	14
		Page 1 of 2

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller <i>Dwg. not required RF 02.11.05</i>	<i>HJ</i>	03.09.19	14
2	PG	Issue P/O: <i>2005608</i> a) Extrude as per Dwg D6008 length = 180" (Ref. D6008-180) b) Material: 7075-T6/T6511 (WW-T-700/7 or QQ-A-225/9 or QQ-A-200/11) ) Seamless aluminum tube c) Minimum ultimate tensile strength = 77ksi d) Minimum tensile yield strength = 66ksi e) <b>Material certification required</b>	<i>U</i>	03.09.22	14
3	RG	Receive and inspect for transit damage <b>Ensure material certification attached</b>	<i>Q</i>	04.01.05	16
4	QC6	Inspect dimensions as per Dwg D6008 and check 180" length	<i>B</i>	04.01.13	16
5	FP	Acid etch and alodine as per QSI 005 4.1 Inside and outside of tube	<i>ME</i>	04.01.13	16
6	LG	Bend as per Dwg D2890 and Folio FT002 <b>Sign Page 2</b>	<i>See sheet 2</i>		
7	QC6	Inspect dimensions per Dwg D2890 <b>Sign Page 2</b>			
8	LG	Deburr and Polish <b>Sign Page 2</b>			
9	FP	Acid etch and alodine as per QSI 005 4.1 Inside and outside of tube <b>Sign Page 2</b>			
10	QC5	Inspect work to Step 9 <b>Sign Page 2</b>			
11	ST	Identify and stock	<i>DP</i>	05/03/07	1
12	AC	Cost / part: <i>854.68</i>	<i>Syc</i>	05.07.21	1
13	DC	Close W/O <i>919.67</i> Inspect Level 21	<i>HJ</i>	05.04.25	1

725.25

Rev	Date	Change	Revised By	Approved
A	99.05.31	New Issue, ECN 200	DM	
B	00.04.11	Remove painting step	EC	
C	02.10.18	Re-format; Added spec	KJ RF	<i>HJ</i>

RELEASED  
02/10/30 RF

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W/O Step	A	B	C	D	E	F	G	H	I	J	K	L
6		DP 04-11-18	DP 05-2-22	DP 05-2-23								
7		Er 04-11-18	FA 05-02-24	# 05-03-02								
8		DP BE- 04-11-18		DP 05-3-7								
9		PD MM 04-11-22		MM 05-03-07								
10				IS 05-03-07								

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